

CLAIMS

What is claimed is:

- 1 1. A folding roll for a folding apparatus, said folding roll comprising:
2 at least one cylindrical surface having at least one frictional area to which
3 frictional material has been applied by thermal spray coating, said at least one frictional
4 area being bounded by deeper areas to which no friction material has been applied.
- 1 2. A folding roll as in claim 1 wherein said at least one frictional area
2 comprises a plurality of four-corned frictional areas.
- 1 3. A folding roll as in claim 1 wherein said at least one frictional area
2 comprises a strip of frictional material running spirally around said cylindrical surface.
- 1 4. A folding roll as in claim 1 wherein said at least one cylindrical
2 surface comprises a plurality of cylindrical surfaces separated by circumferential
3 channels for tape lines, each said circumferential channel having a circumferential
4 surface provided with at least one frictional area to which frictional material has been
5 applied by thermal spray coating.
- 1 5. A folding roll as in claim 1 wherein said frictional material has a
2 depth of about 0.3 mm on said frictional areas.
- 1 6. A folding roll as in claim 2 wherein said folding roll comprises part
2 of a third longitudinal folding apparatus.

1 7. A folding roll as in claim 3 wherein said folding roll comprises part
2 of a folding former.

1 8. A method of producing a folding roll for a folding apparatus, the
2 method comprising:

3 fitting a mask to at least one cylindrical surface, said mask having cutouts
4 shaped and arranged to correspond to the shape and arrangement of desired frictional
5 areas on said at least one cylindrical surface;

6 applying a frictional material by means of thermal spray-coating to said
7 mask and said at least one cylindrical surface via said cutouts; and

8 removing said mask.

1 9. A method as in claim 8 wherein said mask is provided with
2 longitudinal edges, said mask being fitted to said at least one cylindrical surface so that
3 said longitudinal edges form a butt joint.

1 10. A method of producing a folding roll for a folding apparatus, the
2 method comprising:

3 winding a strip-like mask around a cylindrical surface spirally to form turns
4 separated by a gap corresponding to a frictional area extending spirally around said
5 cylindrical surface;

6 applying a frictional material by means of thermal spray-coating to said
7 mask and said at least one cylindrical surface via said gap; and

8 removing said mask.